Work Order ID 91989

91989

October-19-12 7:45:45 AM

Item ID: D2792-130 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: EXTRUSION

Start Date: 10/19/12 **Start Qty:** 80.00 *80* **Cust Item ID:**

Required Date: 11/02/12 **Req'd Qty:** 80.00 *80* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** CY **Date:** 12/10/19 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2792	Rev A1

100 0.00

100

Purchasing

Purchasing

PURCHASING

Memo 0.00

Issue P/O: 18175 a) Extrude as per Dwg D2792 b) Material: 6061-T6 (QQ-A-200/8) c) Tool: MS-19248d) Material certification is required.e) 130 is equal to 130.0"

CY 12/10/19 80

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo 0.00

Ensure material certification and pull test results attached

12/16/19 (9)

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Quality Control

Memo 0.00

Check pull test Report to Dwg D2792 for compliance

DAS 16 9-83 12/11/19

X90

Work Order ID 91989

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October-19-12 7:45:45 AM

Item ID: D2792-130 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: EXTRUSION

Start Date: 10/19/12 **Start Qty:** 80.00 *80*

Required Date: 11/02/12 **Req'd Qty:** 80.00 *80*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: LC	0.00							
130	& Pull Qty x 20 pc For QC Inspection					DC 12/12/03			
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						12/12/3 DJ			
QC	**Memo**	0.00							
Quality Control									

MF 12-11-29

Picklist Print

October-19-12 7:45:44 AM

Work Order ID: 91989

Parent Item: D2792-130

Parent Item Name: EXTRUSION

Start Date: 10/19/12 **Required Date:** 11/02/12

Start Qty: 80.00 **Required Qty:** 80.00

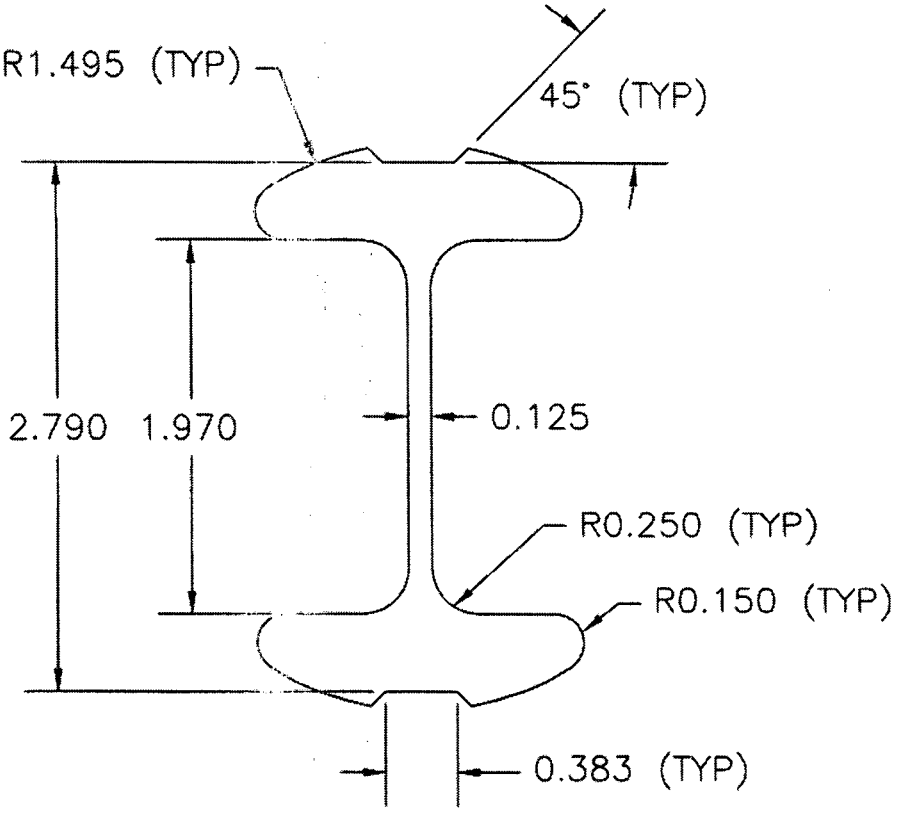
Comments: IPP A98.11.09New IssueKS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130P EXTRUSION		Purchased	No			100	Each	0.0000	1	**80**	80	10/19/12	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED	DRAWING NO. D2792	REV. A SHEET 1 OF 1
DATE 98.08.13		TITLE EXTRUSION	SCALE 1:1

A	98.08.13	NEW ISSUE
A1	01.04.17	ADD NOTE #7

RELEASED
98.08.25 bs



GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

   MINIMUM YIELD TENSILE STRENGTH = 35 ksi
   MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
   MINIMUM ELONGATION = 8 %

   A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

   CL 2110119

2. MANUFACTURED USING CARADON INDALEX DIE # MS-19248
3. BREAK ALL SHARP CORNERS 0.010 MAX.

   W10. 91989

4. NO ID TOOLING MARKS.
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
6. ALL DIMENSIONS ARE IN INCHES.
7. PART NUMBER IS D2792-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2792-145 IS 145" LNG)

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18175

Purchase Order Date 10/19/12
PO Print Date 10/23/12

Order From : VC-SAP001

SAPA CANADA INC
C/O 912420
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	800 563 5120	**Requisition Nbr**	
Vendor Fax	800 563 8310	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr	201355	**Terms**	Net 30
		Currency	CAD
		FOB	Destination-Collect

FAXED

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED $ + duties.

Line Nbr	Reference / Revision ID / Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2792-130P	EXTRUSION	11/14/12 Yes	80.00 Each	Yours ppd	$52.7040	$4,216.32

Special Inst:
EXTRUDE AS PER DWG D2792 REV. A
B91989
MATERIAL: 6061-T6 AS PER QQ-A-200/8
TOOL DIE: # MS-19248
MINIMUM YIELD TENSILE STRENGTH
= 35 KSI
MINIMUM ULTIMATE TENSILE
STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%
SAMPLE FROM EACH BATCH WILL BE
PULL
TESTED TO ASTM STANDARD B221

PO Total: **$4,216.32**

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

u CL

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required - YES NO

Change Nbr: 2 **Change Date:** 10/23/12

- PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE
- ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

Adresse Postale 325, rue Avro
Pointe-Claire, Québec H9R 5W3
Téléphone: (514) 697-5120
Télécopieur: (514) 694-8310

sapa:

P/S#: 835091

VENDU À / SOLD TO

ART AEROSPACE LTD
270 ABERDEEN STREET
AWKESBURY, ONT

6A1K7

EXPÉDIÉ / SHIP TO

DART AEROSPACE LTD
127 [illegible]
HAWKESBURY, ONT

MEME = SAME

K6A1K7

INDICATIONS SPÉCIALES
SPECIAL INSTRUCTIONS

NOTRE NUMÉRO DE COMM.
OUR ORDER NO.

2101516 1

CERTIFIÉ
ISO 9001:2008

CUSTOMER P.S.T.: *6132-5202 SAPA G.S.T. REG NO: R857314058 PROJ:

Required Date:

N° DU CLIENT CUST. NO.	T.P.S. G.S.T.	TAXE DE VENTE PROV. PROV. SALES TAX	N° DE COMM. DU CLIENT CUST. ORDER NO.	DATE DE COMMANDE ORDER DATE	NOTRE DATE DE COMM. OUR ORDER DATE	CONDITIONS TERMS
201355	XXXXXX		13175	12/10/23	12/10/23	

VENDEUR SALESMAN: 27

PAYÉ PPD. ☐ PERC COL. ☐ C.A.D. C.O.D. ☐ F.A.B. F.O.B.

EN BALLOTS BUNDLED AND TAPED ☐ CARTONNÉ CARTONED ☐ CARTONNÉ & INTERCALÉ CARTONED & INTERLEAVED ☐

DATE DE LIVRAISON DATE SHIPPED: 12/11/15

ENVOYÉ PAR SHIPPED VIA: OTTAWA 16 NOV.

N° ITEM ITEM NO.	COMMANDE / ORDERED POIDS WEIGHT	COMMANDE / ORDERED PIÈCES PIECES	N° DE MATRICE SAPA DIE NO.	DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION	ALLIAGE ET TREMPAGE ALLOY AND TEMPER	LONGUEUR LENGTH	PRIX UNITAIRE UNIT PRICE
				E EXTRUDE ONLY			
1	768	80		DUE=2012/11/16 NO07			
				MS 19248 D2792-130P	6061 T6	3303	
				I SUPPORT COMPONENT			
				BUNDLE= 1050445 1050446			

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures

CETTE EXPÉDITION / THIS SHIPMENT BALLOTS BDLES.	POIDS WEIGHT	PCES / PCS.	MONTANT AMOUNT
2	879	90	POIDS EN KGS

FORM 118XF REV 10/12

FEUILLE D'EMPAQUETAGE
PACKING SLIP

LES MARCHANDISES CI-DESSUS ONT ÉTÉ REÇUES EN BONNE ET DUE FORME
THE ABOVE GOODS WERE RECEIVED IN GOOD ORDER

325 rue Avro
Pointe-Claire, QC, Canada H9R 5W3
Téléphone (514) 697-5120
Fac-simile (514) 694-8310

sapa

Rapport des propriétés mécaniques
Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**

Adresse / Address : **1270 ABERDEEN STREET**
HAWKESBURY ONT,
K6A 1K7

Commande Sapa / Sapa order # : **2101518**

Bon de commande / Purchase order # : **18175**

Matrice / Die # : **MS 19248**

Description : **"I"SUPPORT COMPONENT**

Alliage & trempage / Alloy & temper : **6061 T6**

Customer Part # : **D2792-130P**

Contrôle / Control # : **80244-1**

Coulée / Cast # : **55086** 8/21/4/19

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	**45 126**
Contrainte élastique Yield stress (psi)	35 000	**43 003**
% élongation dans 2" % elongation in 2"	8	**13**
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	88 @ 100	**95**

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,68 - 0,72	0,15 - 0,27	0,08 - 0,12	0,20 – 0,24	0,48 – 0,52	0,03 Max	0,05 Max	0,03 Max
6061	0,40 - 0,80	0,70 Max	0,15 – 0,40	0,15 Max	0,80 – 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	—	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221-08 excepté pour la section 8.2 (nombre de spécimen) .

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221-08 except for section 8.2 (number of specimen) .

Sincèrement vôtre, date : **2012-11-13**
Yours truly,

Gilles Pelletier
Technicien de la qualité
Quality technician